

Date: Friday, 18/07/2008 1:10:38 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GUARD
Job Number	: 40658		
Estimate Number	: 13302		
P.O. Number	:	Part Number	: D37751
This Issue	: 18/07/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3775 REVB
First Issue	: / /	Project Number	: N/A
Previous Run	: 39027	Drawing Revision	: B
Written By	:	Material	:
Checked & Approved By	: <u>JLD 08.7.18</u>	Due Date	: 06/08/2008
Comment	Est Rev:A New Issue 08-05-05 JLM Verified By:EC Est Rev:B 08-07-18 revB as per dwg DD verified by:EC		

Qty: 10 Um: A Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MDELRLNR1500	Inventory
-----	--------------	-----------



Comment: Qty.: 0.2468 f(s)/Unit Total : 0.9870 f(s)

1.50" Black Delrin Bar

Batch: 161102961 14107961

20 08/07/31

2.0	DOOSAN LATHE	DOOSAN LATHE
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Comment: DOOSAN LATHE

1- Turn as per Folio FA742 Rev: B & Dwg D3775Rev: B

2-Deburr per dwg D3775

20 08/07/31

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

20 08/07/31 (10)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

3.2 08/07/31

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

51119

20 08/07/31

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 18/07/2008 1:10:38 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUARD

Job Number: 40658

Part Number: D37751

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/08/01

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08.08.01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 40658
Description: Cross tube Assembly GUARD		Part Number: D3775-1
Inspection Dwg:	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.82	+/- .030	2.819				
	.100	+/- .010	.100				
	.73	+/- .030	1.735				
	.050 x 45°	+/- .010 +/- 1/2°	.050 x 45°				
	R.025	+/- .010	.0323				
	.323	+ .005 - .001	.323				
	.600	+/- .010	.665				
	1.500	+/- .010	1.505				
SIDE B							

Measured by: RP	Audited by: JL	Prototype Approval:	N/A
Date: 08/07/31	Date: 08/07/31	Date:	N/A
Rev	Date	Change	Revised by
A		New Issue	KJ/JLM
			Approved

8

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C

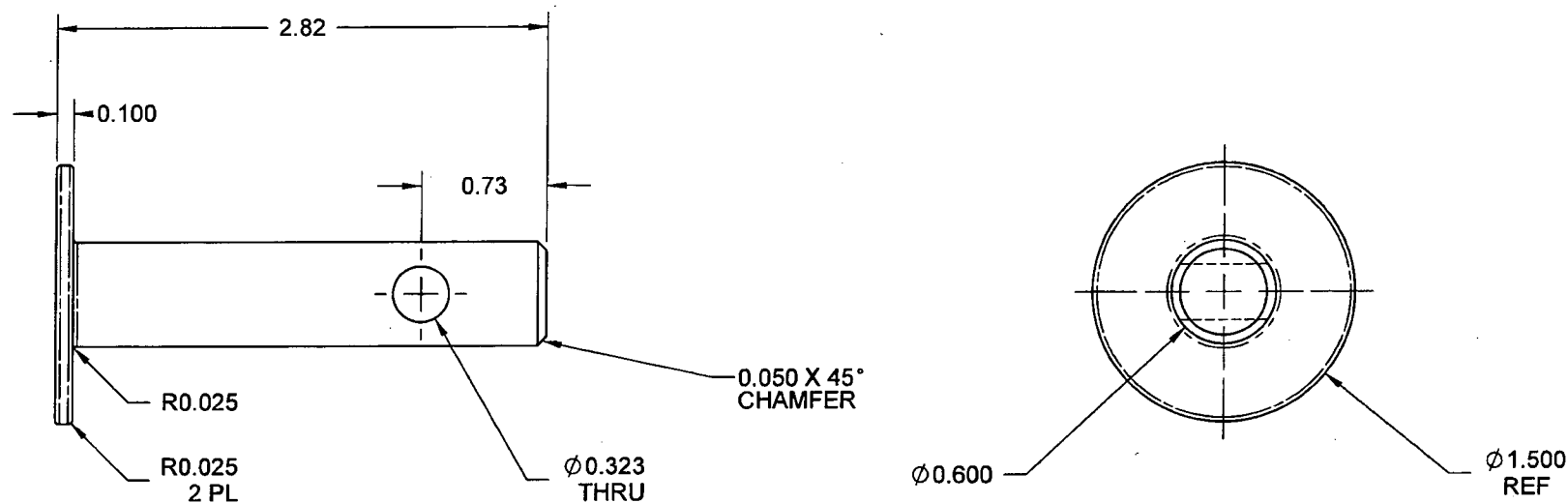
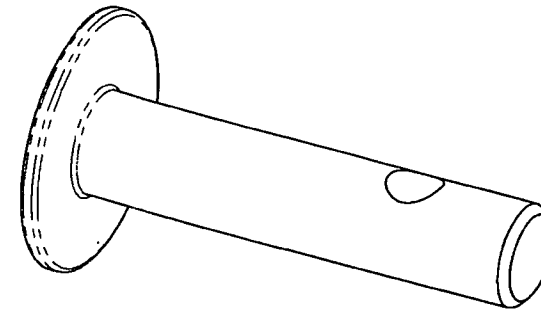
C

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**D3775-1 GUARD** **NOTES:**

- 1) MATERIAL: BLACK DELRIN II 150E OR ACETRON GP ACETAL ROUND BAR (REF. DART SPEC. M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

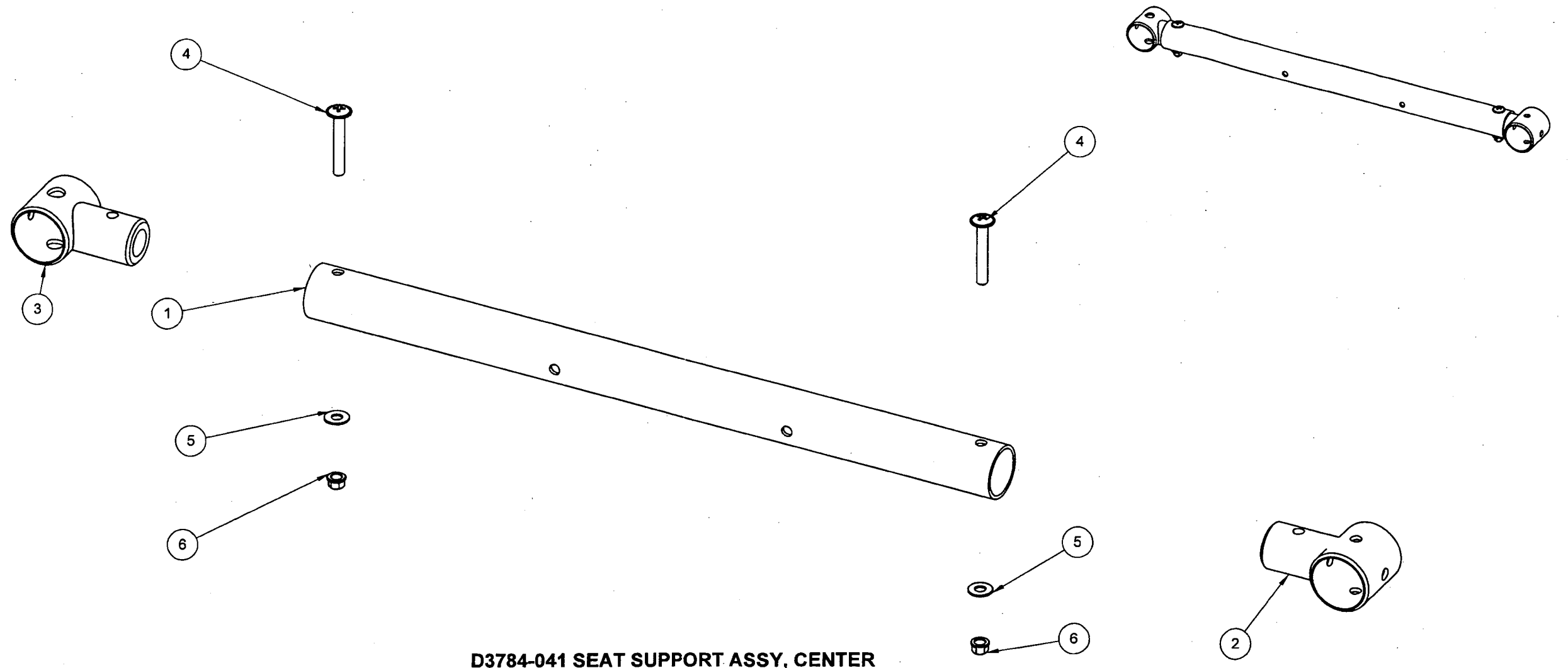
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NO. 40658

B	RE-DESIGN -1 FOR LONGER PROFILE, ELIMINATE -3	HS	08.06.10
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3775	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		GUARD	NTS
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D3784-041 SEAT SUPPORT ASSY, CENTER

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3770-1	TUBE	1
2	D3763-041	END FITTING ASSY	1
3	D3763-045	END FITTING ASSY	1
4	AN525-10R20	SCREW	2
5	NAS1149D0332J	WASHER (AN960JD10L)	2
6	MS21042L3	NUT	2

B
B
B
B

- NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.31 lbs

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B	HARDWARE CHANGE, ASSY CHANGE	HS	08.06.23
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	HS	DRAWING NO.	REV. B
MFG. APPR.	HS	D3784	SHEET 1 OF 5
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DE APPR.	HS	SEAT SUPPORT ASSEMBLY	NTS
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8 7 6 5 4 3 2 1

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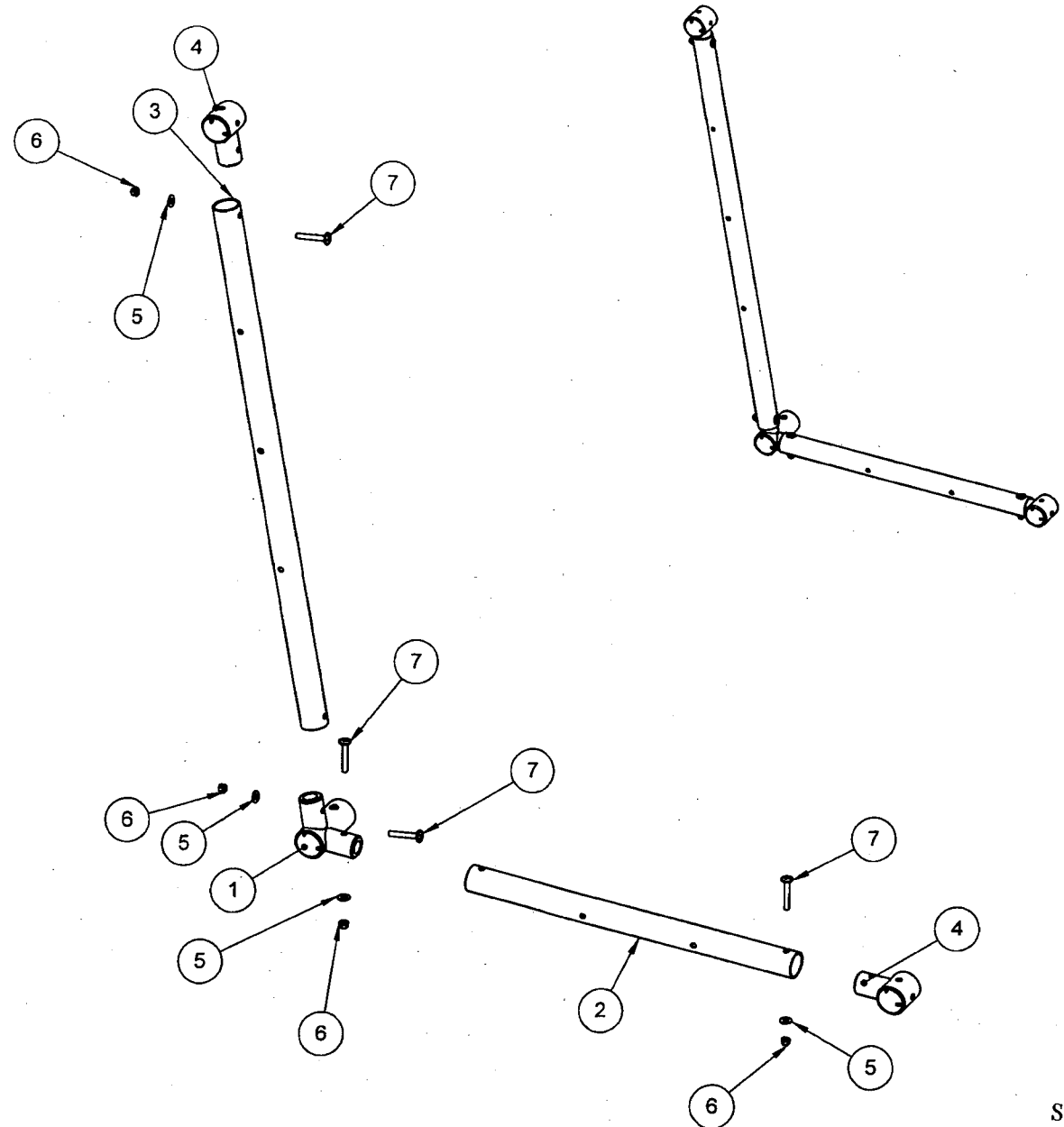
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ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-043)
1	D3763-043	END FITTING ASSY, LH	1
2	D3770-1	TUBE	1
3	D3770-3	TUBE	1
4	D3763-041	END FITTING ASSY	2
5	NAS1149D0332J	WASHER (AN960JD10L)	4
6	MS21042L3	NUT	4
7	AN525-10R20	SCREW	4

B
B
B



D3784-043 SEAT SUPPORT ASSY, LH

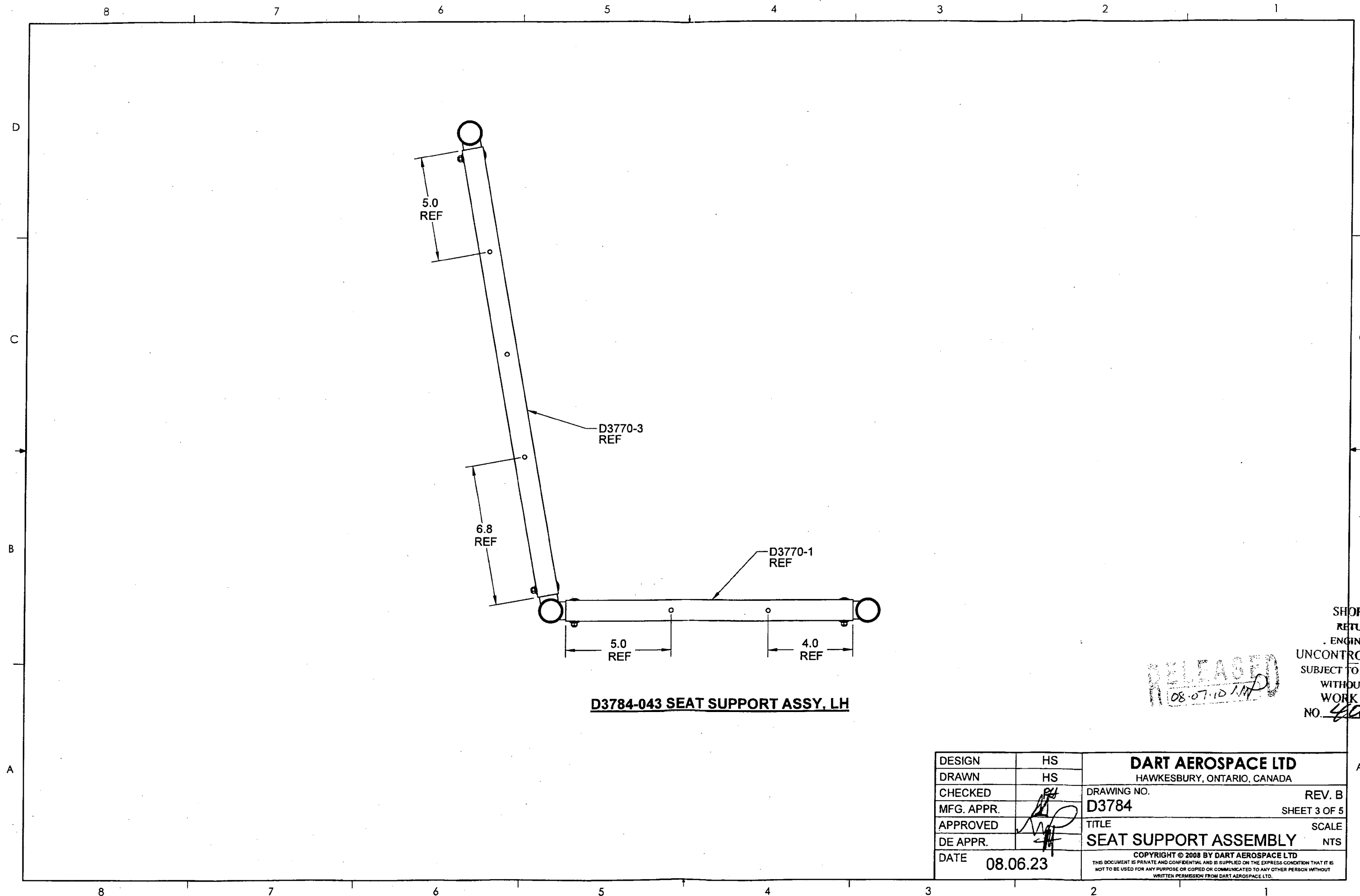
NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.78 lbs

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DATE	08.06.23		

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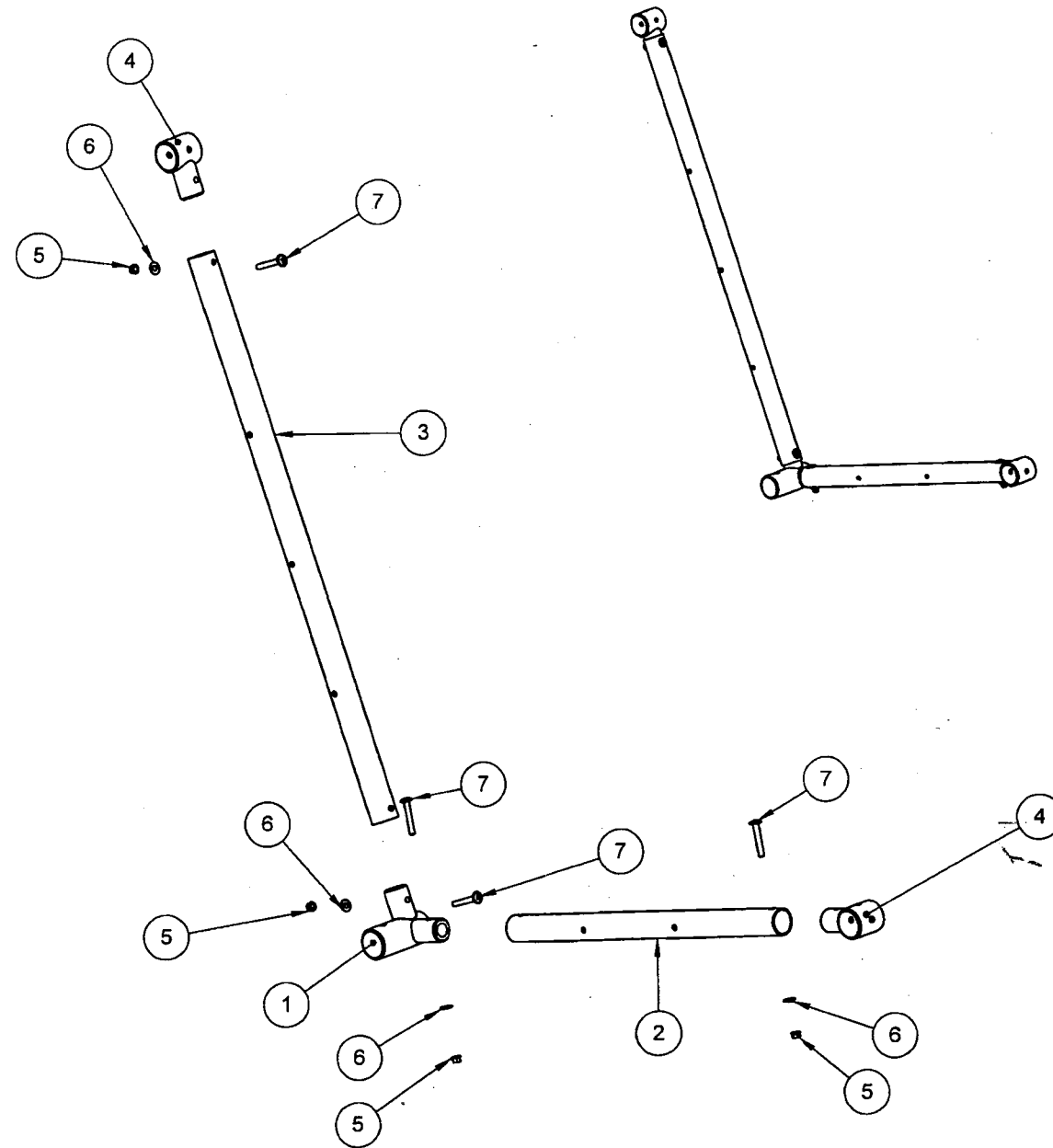
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ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-044)
1	D3763-044	END FITTING ASSY, RH	1
2	D3770-1	TUBE	1
3	D3770-3	TUBE	1
4	D3763-041	END FITTING ASSY	2
5	MS21042L3	NUT	4
6	NAS1149D0332J	WASHER (AN960JD10L)	4
7	AN525-10R20	SCREW	4

B
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D3784-044 SEAT SUPPORT ASSY, RH

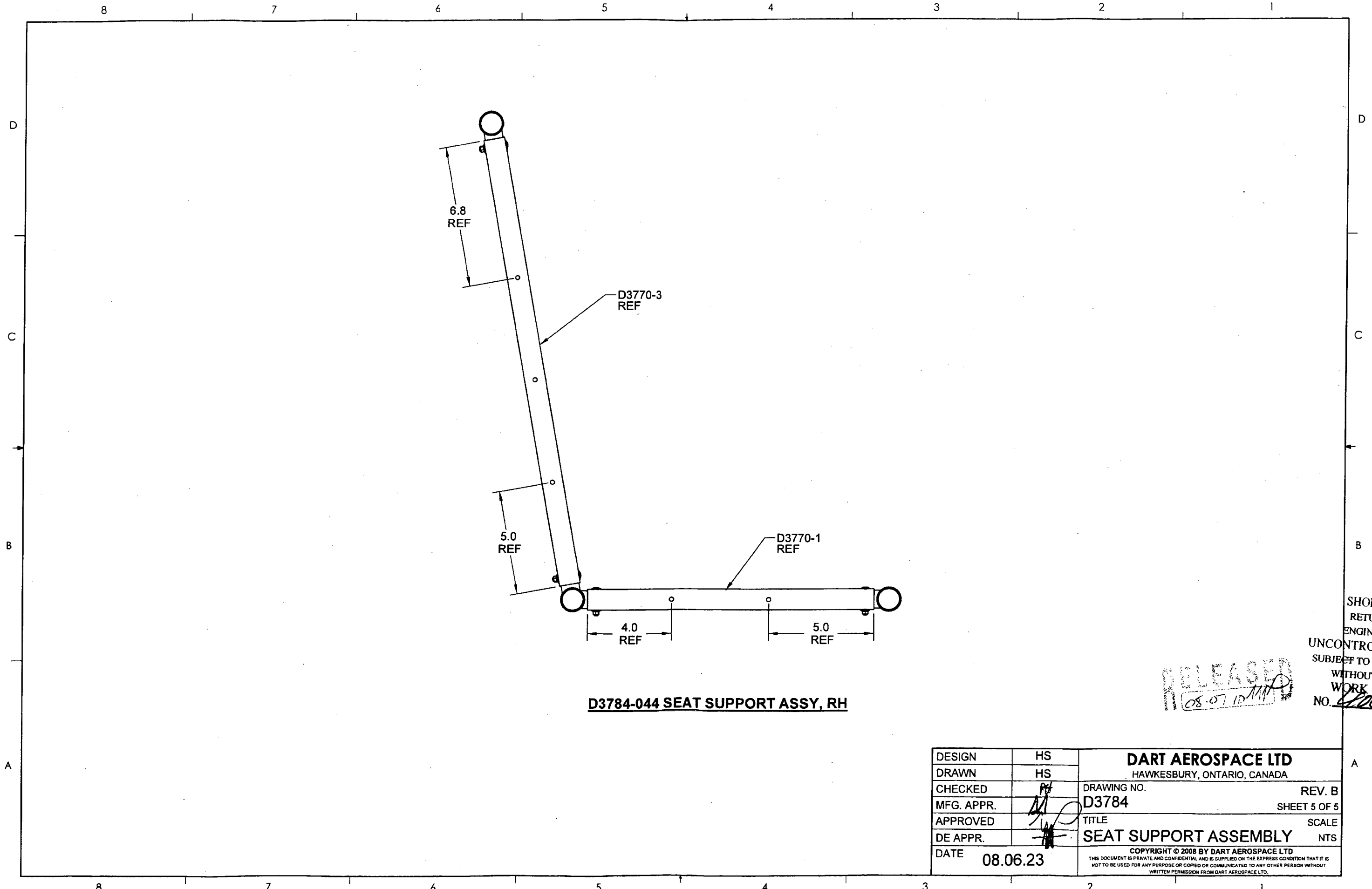
NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.78 lbs

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8 7 6 5 4 3 2 1



D3784-044 SEAT SUPPORT ASSY, RH

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